

Date: Thursday, 11/09/2008 10:41:57 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE, OUTBOARD, LH, 206	
Job Number	: 41974		Part Number	: D26651	
Estimate Number	: 10818		Drawing Number	: D2665 REV.D	
P.O. Number	:		Project Number	: N/A	
This Issue	: 11/09/2008	S.O. No. :	Drawing Revision	: D	
Prsh Rev.	: NC		Material	:	
First Issue	: / /		Due Date	: 10/10/2008	
Previous Run	: 41596		Qty:	/ Um: Each	
Written By	:		/ PO		
Checked & Approved By	: JUL 08.9.11		/ Um: Each		
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processSEC Est Rev:D As per Rev D 07-03-19 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D6101003	Saddle Billet, 7075		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 2X6.25X7.875 Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length	31387 B34644X9	Batch no B34644X9 7ml 08/09/23 (10)
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. 1- Inspect part number and batch number are programmed correctly. 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 4- Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 5- Deburr	31387 B34644X9	7ml 11b 08/09/25
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE		
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	31387 B34644X9	7ml 11b 08/09/25
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	31387 B34644X9	7ml 11b 08/09/25

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2665-1

PAR #: N14

Fault Category: Prod/Machined Parts

NCR: Yes

No

DQA: D

Date: 28/09/24

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
28/09/24	2	1 part scrap run the part at zero PAR 08-024		scrap and destroy replace Qty: 1 Batch: B31387	9M 08/09/24	9P 08/09/24 PER BELOW		
08/09/24	2	THICKNESS AT SKID HOLES WAS 0.005" UNDER BEFORE SLOT MACHINED. THERE IS A 0.100" x 0.040" CHAMFER ON TOP EDGE OF SKID HOLE PROFILING	CP 08/09/24 PQ 08/09/24	0.1235 ^{+0.005} _{-0.005} THICKNESS WAS MAINTAINED AFTER SLOT WAS MACHINED. CHAMFER ACCEPTABLE. PART OK	9M 08/09/24	S 08/09/24 PQ 08/09/24	CP 08/09/24 PQ 08/09/24	

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 41974

Part Number: D26651

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 08/09/26

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



10X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-f 08/09/26

7.0 POWDER COATING POWDER COATING



10X

M108523

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 12:00

OVEN TEMPERATURE: 323°

FINISH TIME: 12:30

m-f 08/09/26

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



10X

Comment: INSPECT POWDER COAT

SA/24 SP

9.0 PACKAGING 1 PACKAGING RESOURCE #1



10X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: U34

8/9/26

SP

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/09/30 SP

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CY08/09/29

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	41974
Description: 206 Saddle, Outboard, Left side				Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.109	.110	.110	.121		
B	0.100	0.140		.130	.130	.131	.131		
C	1.125	1.145		1.135	1.136	1.134	1.135		
D	0.615	0.685		.657	.660	.666	.660		
E	0.240	0.260		.256	.254	.257	.257		
F	1.313	1.343		1.328	1.328	1.328	1.328		
G	0.210	0.230		.225	.224	.225	.225		
H	0.100	0.180		.133	.135	.133	.133		
I	2.470	2.510		2.491	2.491	2.491	2.491		
J	1.565	1.585		1.574	1.575	1.572	1.574		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.100	.100	.100	.100		
M	0.990	1.010		1.007	1.005	1.000	1.000		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.318	.318	.318	.318		
S	0.315	0.322		.317	.317	.317	.317		
T	2.495	2.505		2.500	2.499	2.500	2.500		
U	1.357	1.367		1.359	1.366	1.363	1.363		
V	0.787	0.807		.795	.794	.794	.794		
W	0.540	0.560		.542	.549	.550	.550		
X	1.674	1.684		1.677	1.679	1.678	1.678		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.912	0.932		.924	.924	.925	.925		
AA	0.490	0.510		.500	.500	.500	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	GML	18	Audited by:	J.L.
Date:	08/09/24	10/09/25	Date:	08/09/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	SJL

DART AEROSPACE LTD				Work Order:	4/1974
Description: 206 Saddle, Outboard, Left side				Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5 7/8	5 1/2	7 3/8	8 1/4	By	Date
A	0.100	0.140		.180	.110	.113	.113		
B	0.100	0.140		.130	.130	.130	.130		
C	1.125	1.145		1.130	1.130	1.130	1.130		
D	0.615	0.685		.665	.665	.665	.665		
E	0.240	0.260		.250	.250	.254	.254		
F	1.313	1.343		1.328	1.328	1.328	1.328		
G	0.210	0.230		.220	.220	.220	.220		
H	0.100	0.180		.145	.145	.145	.145		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.575	1.575	1.575	1.575		
K	0.235	0.240		.250	.250	.250	.250		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.318	.318	.318	.318		
S	0.315	0.322		.317	.317	.317	.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.360	1.360	1.360	1.360		
V	0.787	0.807		.800	.800	.800	.800		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.680	1.680	1.680	1.680		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.926	.926	.926	.926		
AA	0.490	0.510		.500	.500	.500	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>8/1/25</i>	Audited by:	<i>JL</i>
Date:	<i>08/09/25</i>	Date:	<i>08/09/26</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	<i>JL</i>
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>JL</i>

DART AEROSPACE LTD		Work Order: 41974
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	9	10	11	3	4	By	Date
A	0.100	0.140		.110	.110	.109				
B	0.100	0.140		.130	.130	.128				
C	1.125	1.145		1.135	1.135	1.135				
D	0.615	0.685		.670	.670	.670				
E	0.240	0.260		.250	.250	.250				
F	1.313	1.343		1.320	1.320	1.320				
G	0.210	0.230		.220	.220	.224				
H	0.100	0.180		.140	.140	.140				
I	2.470	2.510		2.490	2.490	2.490				
J	1.565	1.585		1.575	1.575	1.575				
K	0.235	0.240		.238	.238	.239				
L	0.100	0.120		.110	.110	.117				
M	0.990	1.010		1.000	1.000	1.010				
N	0.510	0.515		.510	.510	.510				
O	5.990	6.010		6.000	6.000	6.004				
P	1.245	1.255		1.250	1.250	1.250				
Q	2.495	2.505		2.500	2.500	2.500				
R	0.313	0.318		.317	.317	.317				
S	0.315	0.322		.315	.315	.315				
T	2.495	2.505		2.500	2.500	2.500				
U	1.357	1.367		1.362	1.362	1.362				
V	0.787	0.807		.800	.800	.800				
W	0.540	0.560		.550	.550	.550				
X	1.674	1.684		1.679	1.679	1.679				
Y	0.257	0.262		.258	.258	.258				
Z	0.912	0.932		.918	.918	.918				
AA	0.490	0.510		.500	.500	.500				
AB	0.178	0.198		.188	.188	.188				
AC										
AD										
AE										
AF										
Accept/Reject										

Measured by:	<i>SJ</i>	Audited by:	<i>JL</i>
Date:	08/09/26	Date:	08/09/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM <i>28</i>	<i>SJ</i>

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. D
PH	CH	D2665	SHEET 1 OF 1
DATE	TITLE		SCALE
06.11.08	SADDLE FWD OUTSIDE HIGH		1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	



